

Date: Thursday, 28/08/2008 10:14:18 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET
Job Number	: 41655		
Estimate Number	: 10260		
P.O. Number	:	Part Number	: D23623
This Issue	: 28/08/2008 S.O. No. :	Drawing Number	: D2362 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 38766	Material	:
Written By	:	Due Date	: 28/08/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>mf 08-08-28</u>		
Comment	: Est: G 00.05.18 Added inspection level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	37477

HAAS CNC VERTICAL MACHINING #1

2.0 HAAS1



Comment: Machine per folio D2362-3

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Inspect Level 2

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

M108523

(10X)

Date: Thursday, 28/08/2008 10:14:19 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 41655

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 450 ^{OF}

FINISH TIME: 2-20

M-L

08/09/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



LD



Comment: INSPECT POWDER COAT

08-09-02

(X)

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B38053

CP 08/09/03

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B38054

CP 08/09/03

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch

M109/09

M107860

CP 08/09/03

(10)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/03

(10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

478

8/9/3

10x

54

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Drawing Name: SUPPORT BRACKET

Job Number: 41655

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03

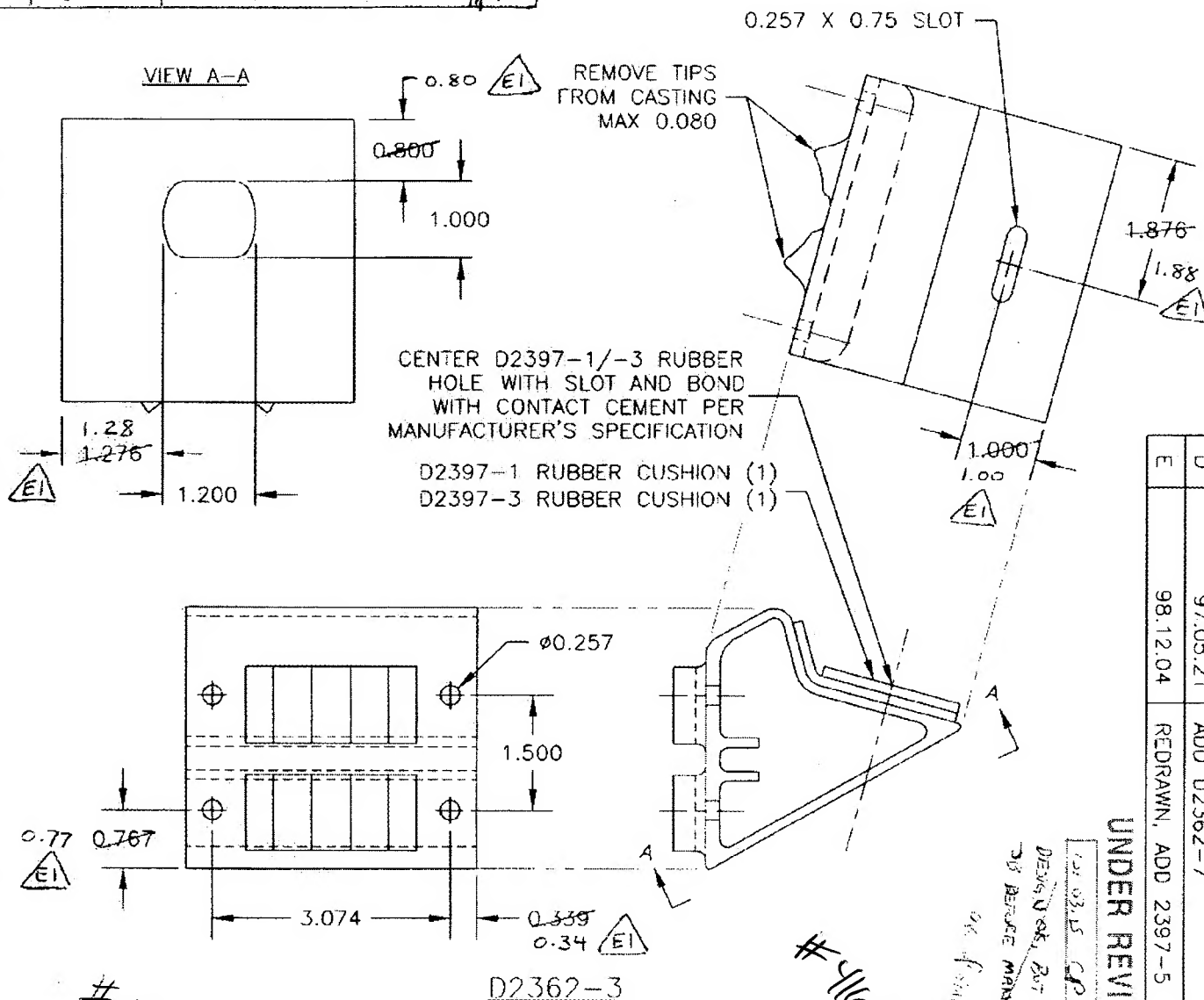
AG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.09.03

EI 03.10.07 TOLERANCE CHANGE ~~RT~~RELEASED
95.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5
SCALE		1:2

NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART



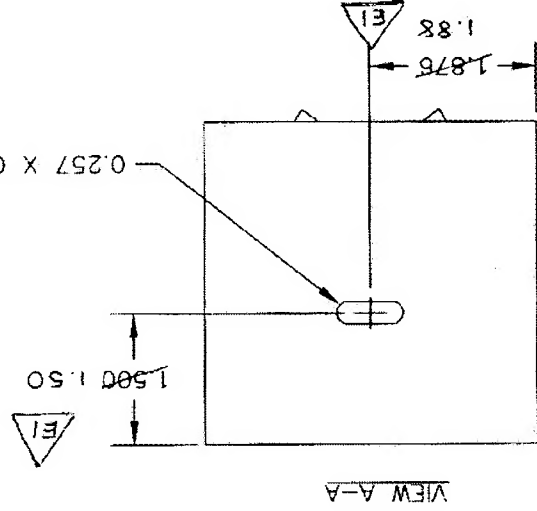
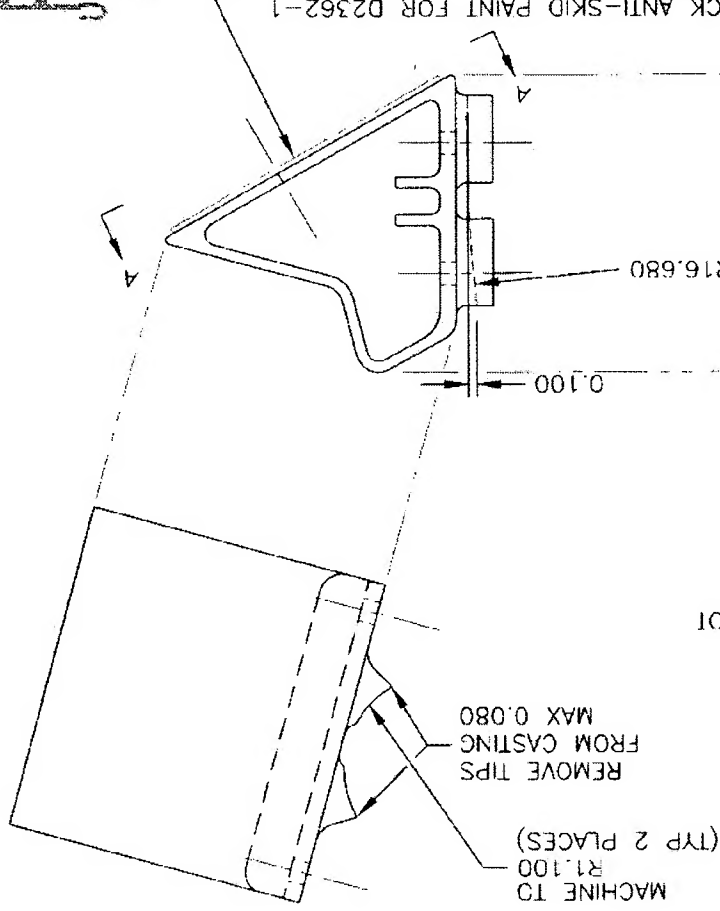
DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
KE	MF	D2362	SHEET 2 OF 3
DATE		TITLE	SCALE
98.12.04		STEP SUPPORT BRACKET	1:2

RELEASED
98.12.14
UNDER REVIEW

D2362-5 CP

DESIGN OK, BUT CHECK BY
D23 BEARING MANUFACTURE

4/16/95



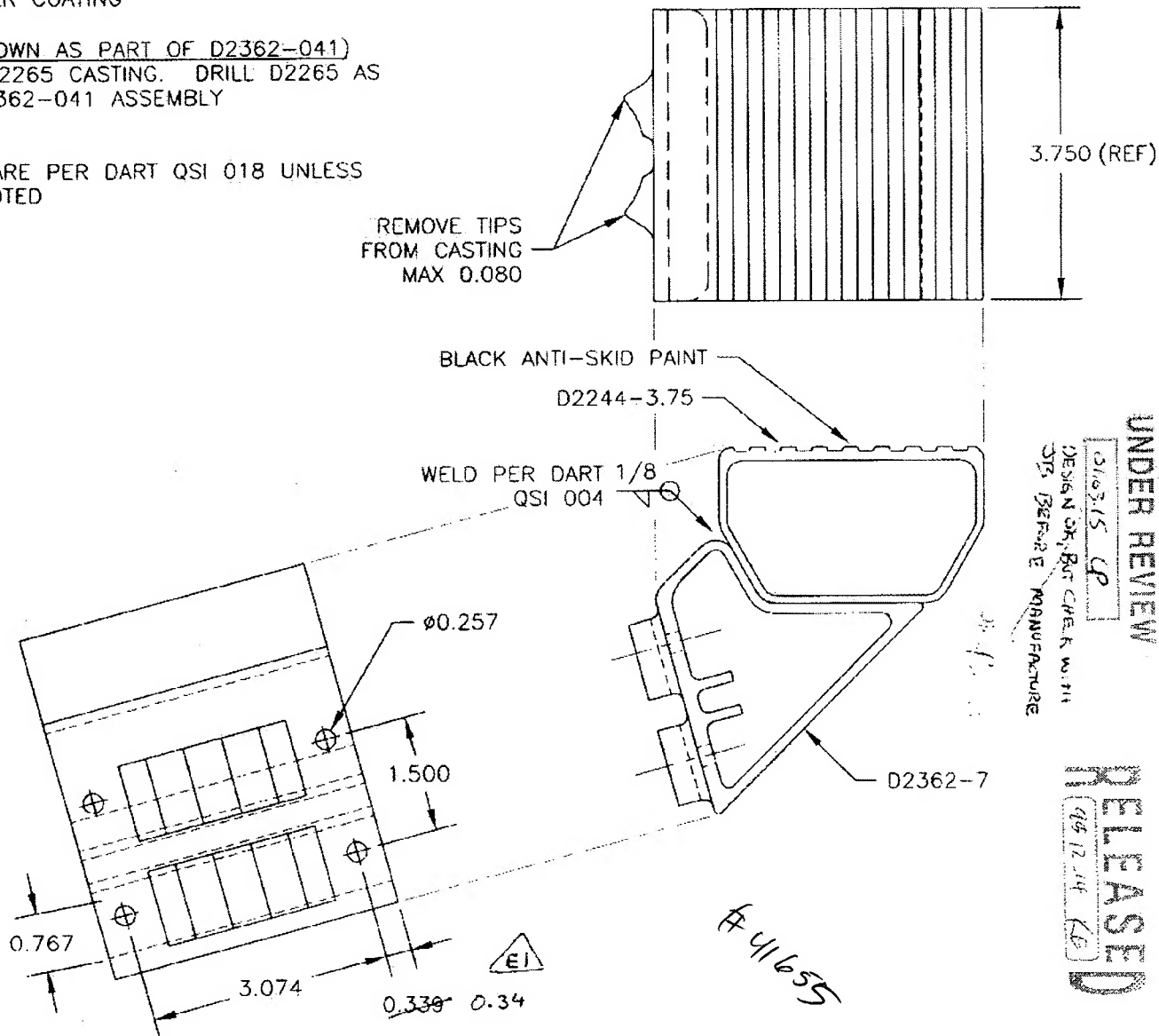
NOTES:
D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
MAKE FROM D2265
D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DART



DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	APPROVED	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DATE	DRAWING NO.	REV. E
KE	98.12.04	D2362	SHEET 3 OF 3
		TITLE	SCALE
		STEP SUPPORT BRACKET	1:2

UNDER REVIEW

3/10/15 CP
DESIGN OK, BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.04 KE

